Date: Thursday, 07/02/2008 11:11:40 AM
User: Linda Lacelle

Process Sheet SPLIT

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPAD
Job Number	: 37292 -1		
Estimate Number	: 12712		
P.O. Number	:	Part Number	: D35371
This Issue	: 07/02/2008 S.O. No. :	Drawing Number	: D3537 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 36714	Material	:
Written By	:	Due Date	: 28/02/2008 Qty: 100 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 07-02-14 JLM		

62

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet

Comment: Qty.: 0.1113 sf(s)/Unit Total : 11.1300 sf(s)
M304S16GA .063" 304 SS SHEET
Batch: 106 360 RB 8-2-12

2.0	WATER JET	FLOW WATER JET

Comment: FLOW WATER JET
1-Cut as per Dwg D3537
Dwg Rev: C
Prog Rev: C
RB 8-2-12
129
2-Deburr if necessary RB 8-2-12

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

RB 8-2-12
Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK

05/02/12 (125) counts
Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE

Comment: NC BRAKE
1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.
2-Identify as D3537-1
05/02/12 (129) SB

Form: rprocess

Date: Thursday, 07/02/2008 11:11:40 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** WEARPAD

Job Number: 37292 **Part Number:** D35371

Job Number:

P12 LAST PAGE

Seq. #:	Machine Or Operation:	Description :	
6.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	M 08/04/07 Took 10 for testing

Comment: LARGE FABRICATION RESOURCE 1

Qty	Description	Batch
A/R	2059B Hardcoat	M106834

1-Weld as per Dwg D3537 using Jig DT 8210 M107051 SS
2-Remove any weld that penetrated through Wearpadif necessary 08-04-14 SS (49x)

7.0	QC10	VISUAL WELDING INSPECTION	M 08/03/24

Comment: VISUAL WELDING INSPECTION PD 08-04-14 S 08/04/14 (45)

8.0	QC5	INSPECT WORK TO CURRENT STEP	

Comment: INSPECT WORK TO CURRENT STEP S 08/04/14 (45)

9.0	POWDER COATING	POWDER COATING	M106442 (45)

Comment: POWDER COATING
Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 FL 08/04/15

10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION	(45X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION M. L 08/04/15

11.0	PACKAGING 1	PACKAGING RESOURCE #1	(45X)

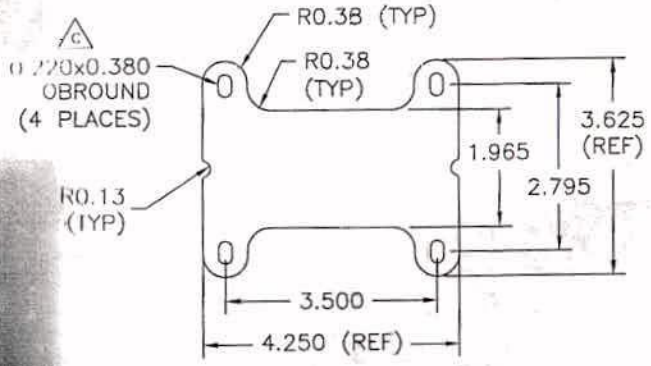
Comment: PACKAGING RESOURCE #1
Identify and Stock Location: F-P 20 M. L 08/04/15

12.0	QC21	FINAL INSPECTION/W/O RELEASE	08/04/16

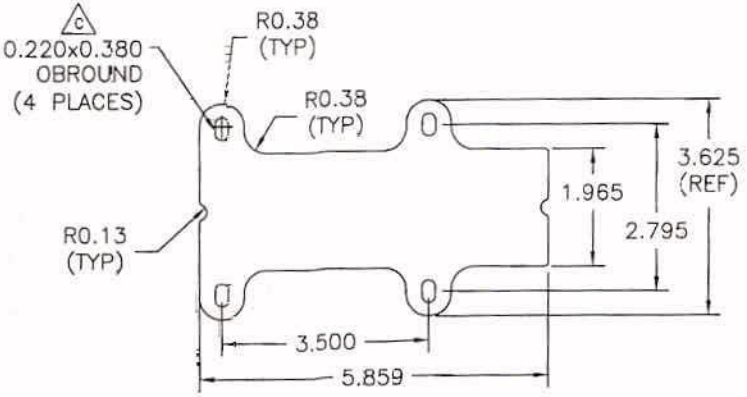
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion MF 08-04-16

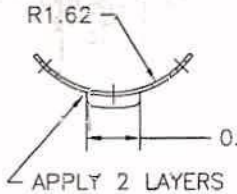
D3537-1F FLAT PATTERN



D3537-3F FLAT PATTERN

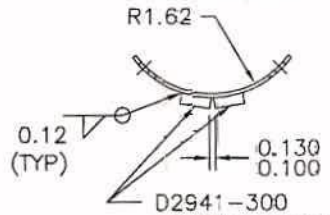


SECTION A-A



APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.188 TO 0.250 THICK

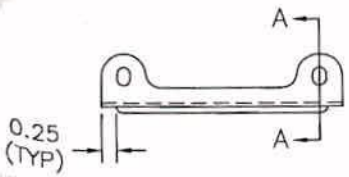
SECTION B-B



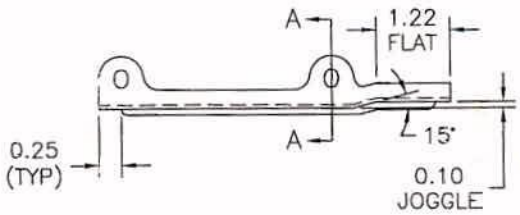
D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

RELEASED 07.05.03 AE per ECN 952

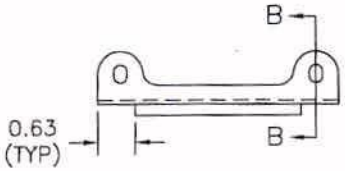
D3537-1 LONGITUDINAL BEND
(MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND
(MADE FROM D3537-3F)

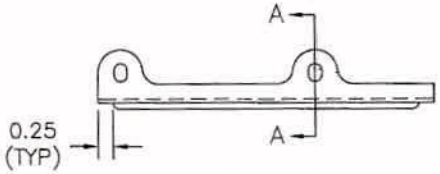


D3537-5 LONGITUDINAL BEND
(MADE FROM D3537-1F)



W037292

D3537-7 LONGITUDINAL BEND
(MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK) (REF DART SPEC. M304S16GA)
2) BREAK ALL SHARP CORNERS 0.063 MAX
3) WELD PER QSI 004
4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE

DESIGN: CB	DRAWN BY: PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO. D3537	REV. C
DATE: 07.04.13		TITLE: WEARPAD	SCALE: 1:2
			SHEET 1 OF 1

DART AEROSPACE LTD	Work Order:	37292
Description: WEAR PAD	Part Number:	D3537-1
Inspection Dwg: D3537-1 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
270 X 380	+/- .010	270 X 380	X			
1.965	+/- .010	1.969	X			
2.795	+/- .010	2.795	X			
3.625	+/- .010	3.624	X			
3.500	+/- .010	3.501	X			
4.750	+/- .010	4.751	X			

Measured by:	MB	Audited by:		Prototype Approval:	
Date:	8-2-12	Date:	28/8/12	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: D3537-1 **PAR #:** N/A **Fault Category:** Prod / Fab. Large **NCR:** (Yes) No **DQA:** D **Date:** 08/04/14

QA: N/C Closed: _____ **Date:** _____

NCR: 37292

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B: Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
08/04/14	#60	four PARTS SCRAP. 3 parts were ground too much - 1 has it ground ~~under~~ under caution a large step	RESI042	SCRAP and Destroy all four (Qty x4) Parts. NO REPAIR	SP 08-04-14	08/04/14	RESI042	08/04/14
		2 have the end of the Plate ground Down to under 0.050". the fourth PART was · Re WELDED in A area were there was a Burn out in mat.	RESI042	inform welder that it is not acceptable to Repair a mistake with out informing QC or Eng.	08/04/14	08.04.14	RESI042	08/04/14
		RL employee thought it was ok to fix mistakes and was it a Problem.	RESI042				RESI042	

NOTE: Date & initial all entries